

Work Order ID 69920

Tuesday, May 24, 2011 2:19:11 PM



Page 1

Item ID: D3954-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Ratchet Lug

Start Date: 5/24/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

10-0524

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3954	B

100

0.00



Mill Conv

Memo

0.00

Conventional Milling Machine

mill to size

11/05/26

12

4

110

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3954

Dwg Rev: 8

Prog Rev: 13

2-Deburr if necessary

1311-5-25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69920

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Page 2

Item ID: D3954-7

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Revision ID:

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Required Date: 5/31/2011 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

KB 11-5-25

12

125

0.00

Mill Conv

Memo

0.00

Conventional Milling Machine

Open hole to .75" max and mill as per Dwg D3954

11/05/27

12

127

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

11/05/30

12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Work Order ID 69920

Tuesday, May 24, 2011 2:19:11 PM



Page 3

Item ID: D3954-7

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Setup Start



Revision ID:

Stop



Item Name: Ratchet Lug

Start Date: 5/24/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140



SprayPaint

Spray Painting

Memo

1- SPRAY PAINT YELLOW AS PER DWG
A/R BATCH: N/A

0.00

0.00

150



QC

Quality Control

QC14- Inspect Spray Paint

Memo


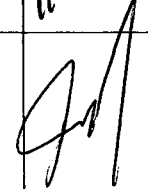
0.00

0.00

START Time : 1:00
OVER Temp : 400°F
FINISH Time : 1:30

12x / M-L 11/05/30

Pto →

W/O: 69920		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
11/5/30	# 120	Perm. chg. change to QC3 inspection	BL	11-5-30	12:		 11/5/30	
								

Part No: D3954-7 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 69920

Tuesday, May 24, 2011 2:19:12 PM



Page 4

Item ID: D3954-7

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Revision ID:

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Item Name: Ratchet Lug

Start Date: 5/24/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Packaging

Identify as per dwg & Stock Location: 77

0.00

Memo

0.00

Packaging

11/5/30 (12)

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/5/31 (12)11-05-31
(12)

W/O:		WORK ORDER CHANGES						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, May 24, 2011 2:19:17 PM

Page 1

Work Order ID: 69920

Parent Item: D3954-7

Parent Item Name: Ratchet Lug



Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 6.00

Required Qty: 6.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M1010B1.000X02.000

Purchased

No

f

6.6000

3.157895



B11-5-75

1010-1025 Steel Bar 1.00 x 2.00

Location

Loc Qty

Loc Code

MAT035

6.6

110368

114431

6.6

1010 1.00" x 12.00"

CL11/05/25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

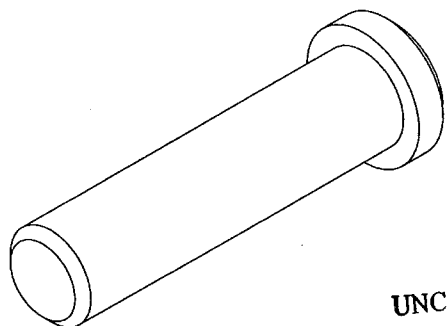
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DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

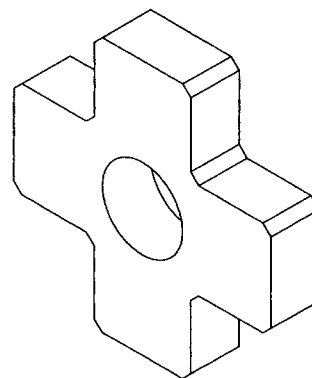
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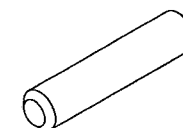
NOTE: Date & initial all entries



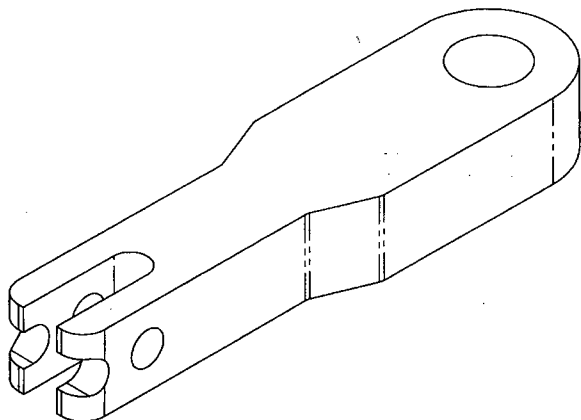
D3954-1 GWT PIN



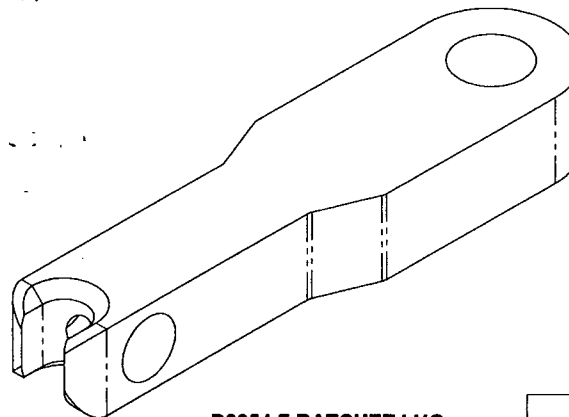
D3954-3 GWT KNOB



D3954-9 GWT CHAIN PIN



D3954-5 CHAIN LUG



D3954-7 RATCHET LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69920

RD11-05-24

RELEASED
2009-10-19
MP

B	MATERIAL UPDATE FOR ALL COMPONENTS WAS STAINLESS STEEL IS CARBON STEEL FOR ALL COMPONENTS. FINISH FOR ALL COMPONENTS WAS RED POWDER COAT IS YELLOW SPRAY PAINT.		AJS	09.10.15
A	NEW ISSUE		AJS	09.05.26
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS/DSTOW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3954 REV. B SHEET 1 OF 3 TITLE MISC MACHINED PARTS GWT KIT SCALE NTS DATE 09.10.15 <small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		
DRAWN	AJS			
CHECKED	<i>[Signature]</i>			
MFG. APPR.	<i>[Signature]</i>			
DE APPR.	N/A			

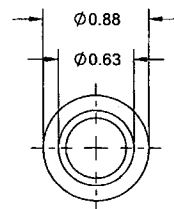
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

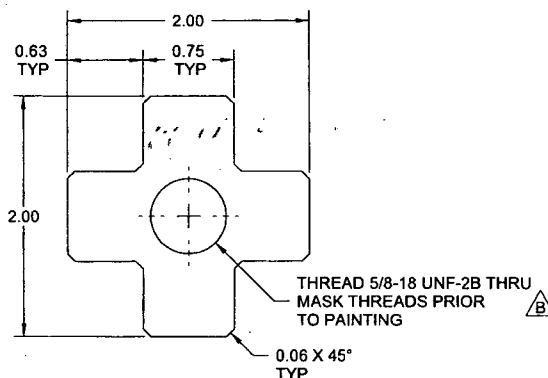
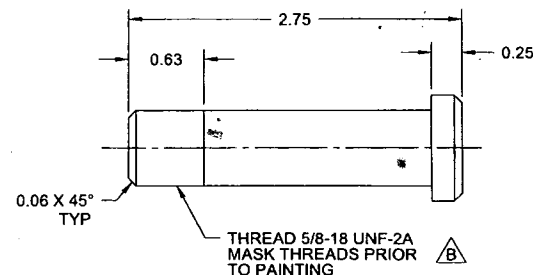
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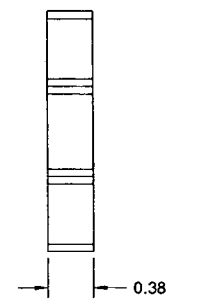
NOTE: Date & initial all entries



D3954-1 GWT PIN



D3954-3 GWT KNOB



NOTES:

1) MATERIAL -1: AISI 1010-1025 MILD STEEL ROUND BAR
PER DART SPEC M1018-R

-3: AISI 1010-1025 MILD STEEL SHEET
PER DART SPEC MS1010-S

OR: AISI 1010-1025 MILD STEEL BAR
PER DART SPEC M1010-B

ALTERNATE MATERIAL:

-1: AISI 303/304 STAINLESS STEEL ROUND BAR
REF DART SPEC M303/304R

-3: AISI 303/304 STAINLESS STEEL SHEET
REF DART SPEC M303/304S

OR: AISI 303/304 STAINLESS STEEL BAR
REF DART SPEC M303/304B

- 2) FINISH: SPRAY PAINT YELLOW WITH BERTRAND CG1031B PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -1: 0.26 lbs
-3: 0.23 lbs

4069920

RELEASED
2009-10-19

DESIGN	AJS/DSTOW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3954	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS
DATE	09.10.15	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

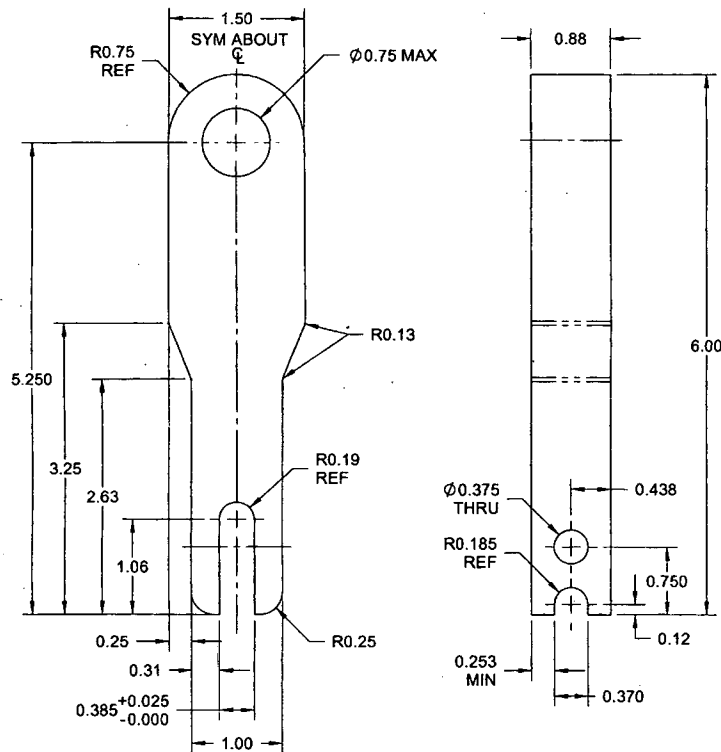
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3954-5 CHAIN LUG

NOTES:

1) MATERIAL: -5/-7: AISI 1010-1025 MILD STEEL BAR
PER DART SPEC M1010-B

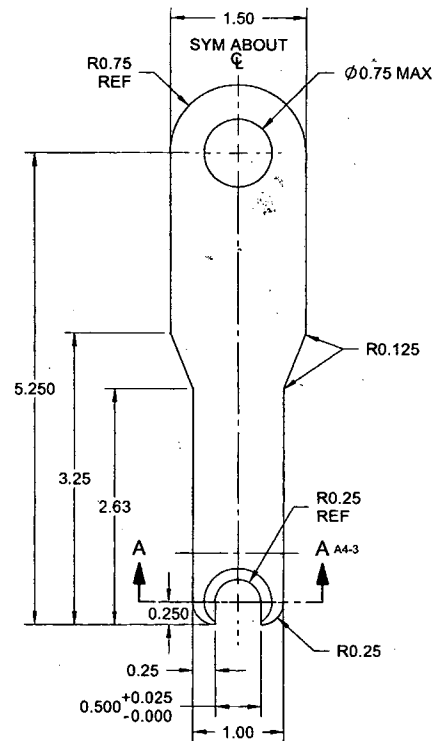
9: AISI 1010-1025 MILD STEEL ROUND BAR
PER DART SPEC M1018-R

ALTERNATE MATERIAL:

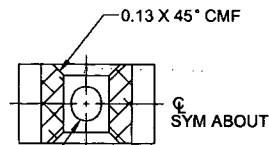
-5/-7: AISI 303/304 STAINLESS STEEL BAR
REF DART SPEC M303/304B

-9: AISI 303/304 STAINLESS STEEL ROUND BAR
REF DART SPEC M303/304R

- 2) FINISH -7 ONLY: SPRAY PAINT YELLOW WITH BERTRAND CG103IB PER DART QSI 005 4.2
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -5/-7: 1.56 lbs EACH
-9: 0.05 lbs

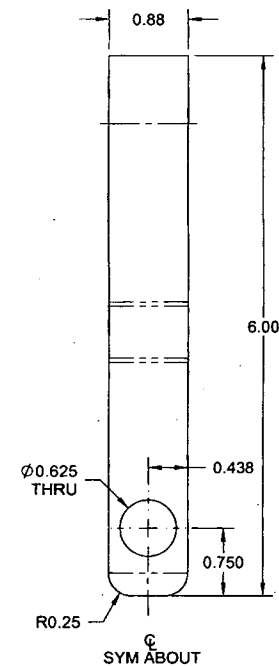


D3954-7 RATCHET LUG




WALL BREAK THRU
ACCEPTABLE

SECTION A-A C3-3



D3954-9 GWT CHAIN PIN

RELEASED
2009-10-19

DESIGN	AJS/DSTOW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3954	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS
DATE	09.10.15	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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